

### Abstract

A structure for securing an insert (21) to an insert drill in which the insert (21) is precisely arranged in a mounting slot (3) formed on an end of a holder (1) of the insert drill. The insert drill includes the holder (1) having the mounting slot (3), a shank hole (5), a first bolt hole (7); the insert (21) having a shank part (23) and an inclined groove (25); and a tie bolt (31). The insert securing structure includes a second bolt hole (41) formed on a predetermined portion of the outer surface of the holder (1), a guide groove (29) longitudinally formed on an engaging surface of the insert (21), and a guide bolt (41) tightened into the second bolt hole (9), with an inside end of the guide bolt (41) projected into the mounting slot (3), so that the inside end of the guide bolt (41) is received into the guide groove (29) when the insert (21) is inserted into the mounting slot (3) of the holder (1).